

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019897**Date Inspected:** 13-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Kelly Leavitt, was present during the times noted above for observations relative to the work being performed.

Bay 10

This QA Inspector observed the following work in progress for Bay 10.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Guo Tam Fei.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA Inspector.

Component; OBG Bike Path

PCMK: BK007A6-001

Weld No: 002, 007

Welder: 053869, 040434

WPS-B-P-2132-ESAB

Component; OBG Bike Path

PCMK: BK007A8-001

Weld No: 002, 007

Welder: 040403, 057258

WPS-B-P-2132-ESAB

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Component; OBG Bike Path

PCMK: BK007A6-001

Weld No: 001,165

Welder: 052075

WPS-B-P-2132-ESAB

This QA Inspector observed the following work in progress for Bay 10.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Guo Tam Fei.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA Inspector.

Component; Tower

PCMK: SSD1-TC6-1C/D

Weld No: 023

Welder: 056200, 500363

WPS-B-P-2214-TC-U5b

Component; OBG Bike Path

PCMK: BK010A2-001

Weld No: 022

Welder: 056364

WPS-B-T-2211-B-U2

Component; OBG Bike Path

PCMK: BK010A2-001

Weld No: 024

Welder: 052493

WPS-B-T-2211-B-U2

Bay 11

This QA Inspector observed the following work in progress for Bay 11.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Zhu Feng.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA Inspector.

Component; Tower Top Plate

PCMK: GTSA5-B/G

Weld No: 11A, 11B

Welder: 040690, 044541

WPS-B-P-2212-TC-U5b

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Component; Tower Top Plate
PCMK: GTSA5-B/G
Weld No: 12A, 12B
Welder: 040365, 040581
WPS-B-P-2212-TC-U5b

Component; Tower Top Plate
PCMK: GTSA5-B/G
Weld No: 13A, 13B
Welder: 052910, 040552
WPS-B-P-2212-TC-U5b

Component; Tower Top Plate
PCMK: GTSA5-B/G
Weld No: 14A, 14B
Welder: 040723, 046769
WPS-B-P-2212-TC-U5b

Trial Assembly

This QA Inspector observed the following work in progress for Trial Assembly.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Li Young.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA Inspector.

Component; OBG 12 CE
PCMK: SEG3002N
Weld No: 090
Welder: 047353
WPS-B-T-2232-ESAB

Component; OBG 12 BE
PCMK: SEG3003T
Weld No: 035
Welder: 047353
WPS-B-T-2232-ESAB

This QA Inspector observed the following work in progress for Trial Assembly.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Li Young.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA Inspector.

Component; OBG 12 BE to 12CE

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PCMK: SEG3002A

Weld No: 004

Welder: 044515

WPS-B-T-2214-B-U2

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No significant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Leavitt,Kelly
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Quality Assurance Inspector

Reviewed By:	Riley,Ken
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QA Reviewer
